


Date: Wednesday, 14/11/2007 1:24:20 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: G10608-1
Job Number	: 35387		
Estimate Number	: 10804		
P.O. Number	: <i>NA</i>	Part Number	: D3637041
This Issue	: 14/11/2007	S.O. No.	: <i>NA</i>
Prsht Rev.	: NC	Drawing Number	: RE-IDENTIFY
First Issue	: 25/10/2007	Project Number	: <i>NA</i>
Previous Run	: 35384	Drawing Revision	: <i>NA</i>
	Type : SMALL /MED FAB	Material	: <i>NA</i>
Written By	: 	Due Date	: 01/11/2007
Checked & Approved By	: _____	Qty:	11 Um: Each
Comment	: _____		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

REMOVE FROM STOCK:

G10608-1 M105654 (D3637-1)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

weld over countersinks

316 SS ROD B M104721

+ *grind smoother*

FC 07/11/19

(11)

3.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

D 07-11-19

(11)

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

INSTALL NUTPLATE PER DRWG D3637 REV.A

ml 07/11/20

(11)

5.0	G106081	Bracket
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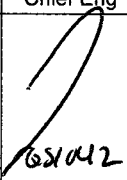
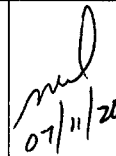

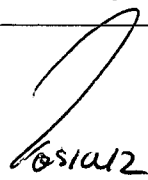
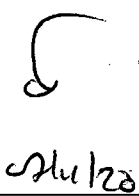


Comment: Qty: 1.0000 Each(s)/Unit Total: 11.0000 Each(s)

Doubler

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 17 Date: 07/11/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/20	4	C'sink not deep enough. Bad install of rivets.		took out 2 rivets and nut plate, Re-do C'sink. Replace 2 rivets MS20427 AD and 1 nut plate MS21059L4 M102959 M1563-3	 07/11/20			

NOTE: Date & initial all entries

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User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: G10608-1

Job Number: 35387

Part Number: D3637041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21059L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 11.0000 Each(s)
Nutplate

M102959

✓ mel 07/11/19

7.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 22.0000 Each(s)
Rivet

M1563

mel 07/11/19

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

↓ 07/11/20

(X11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

RESTOCK AS D3637-041
USING NEW B/N

ST. 267

KS

07/11/20

(11)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(11)
07/11/20

Job Completion



u 07.11.20

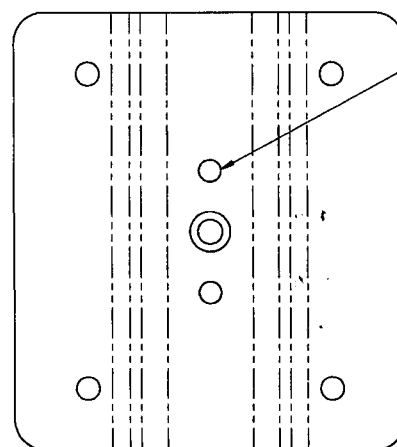
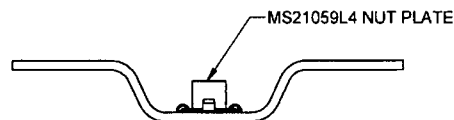
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

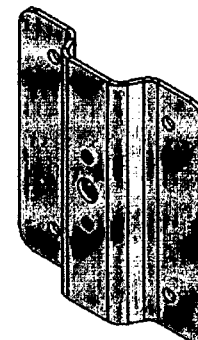
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



W/O 35387

**D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)**

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

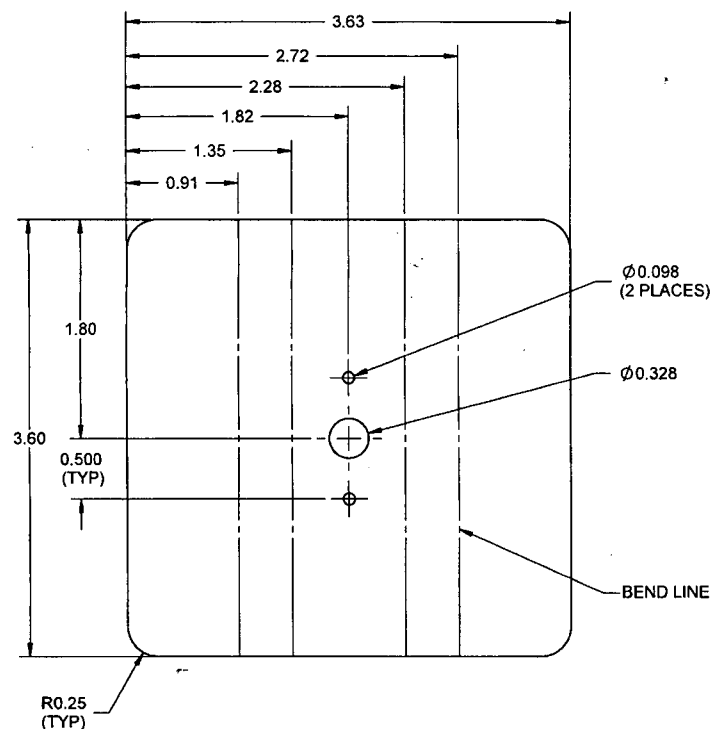
D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

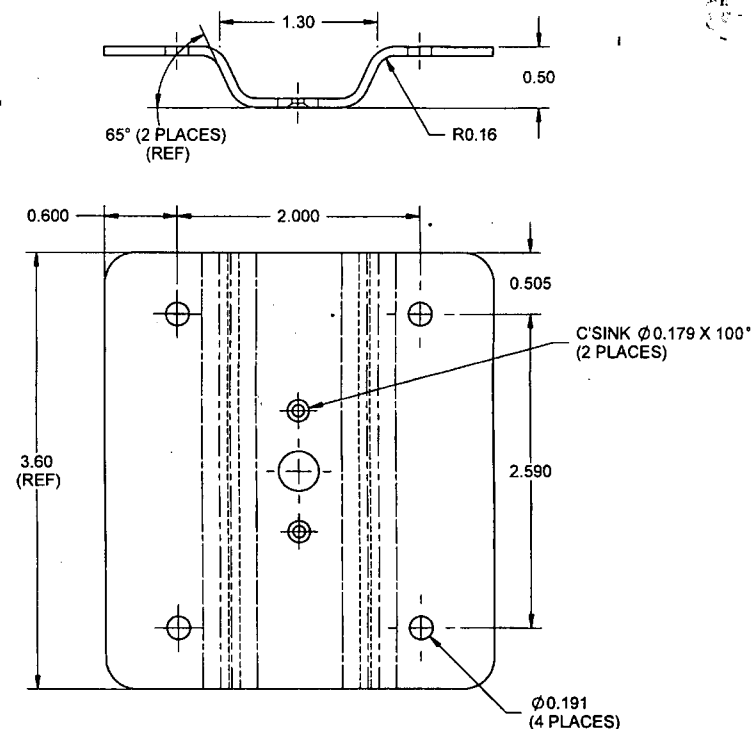
RELEASED
07.09.07

REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	GP		
MFG. APPR.	BE		
APPROVED	MP		
DE APPR.	ST		
DATE	07.07.27		

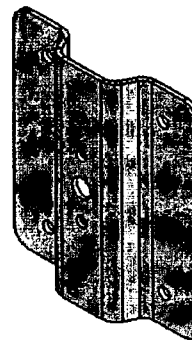
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3637		REV. A	
TITLE BRACKET		SHEET 1 OF 3	
DATE 07.07.27		SCALE 1:1	
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D3637-1F FLAT PATTERN



**D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)**

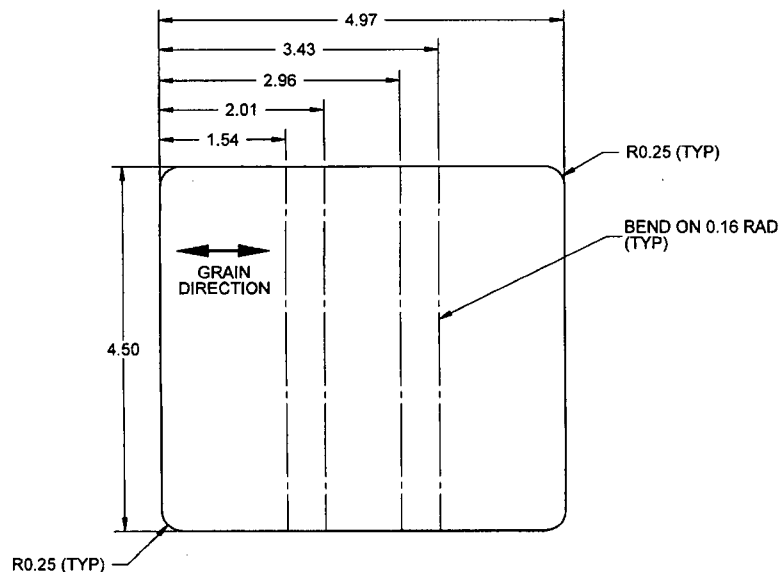


RELEASED
07.09.07

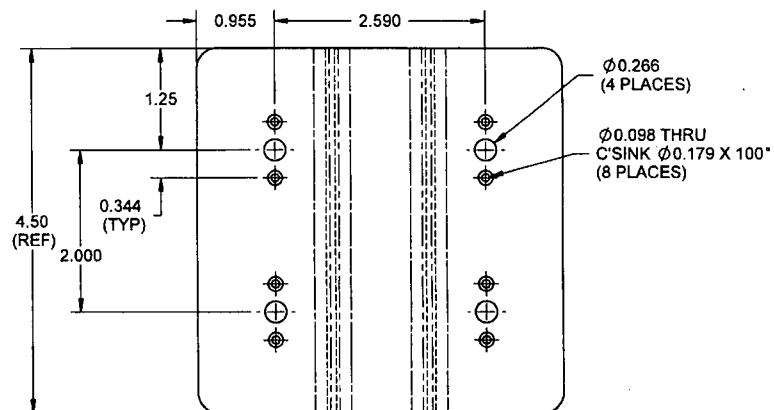
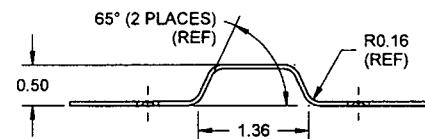
D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

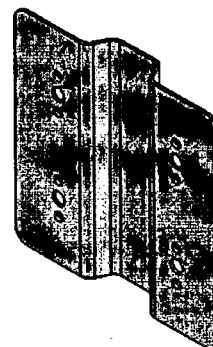
DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	JP	D3637	SHEET 2 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BRACKET	1:1
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D3637-3F FLAT PATTERN



**D3637-3 BRACKET
(WAS GENEVA P/N G10609-1)**



RELEASED
07.09.07

- D3637-3 NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-3" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.32 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	CF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CF	DRAWING NO.	REV. A
MFG. APPR.	E	D3637	SHEET 3 OF 3
APPROVED	CF	TITLE	SCALE
DE APPR.	CF	BRACKET	2:3
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L Lacelle

From: Leanne Elsliger [lelsiger@dartaero.com]
Sent: November 5, 2007 4:20 PM
To: 'Linda Lacelle'
Subject: D3637-1

Linda – the Geneva p/n G10608-1 that we gave Dart p/n D3637-1 has two countersinks that we do not have on our part. I forgot about these until Eric D brought them to my attention (sorry). There are 11 of them. You can either scrap them or rework the parts by welding.

Leanne

Leanne Elsliger, P.Eng
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F: (613) 632-9311

06/11/2007